

Work Order ID 142573

142573

Page 1

Thursday, March 10, 2016 10:48:00 AM

Item ID: D3885-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Standard Web

Start Date: 3/14/2016 Start Qty: 25.00 *25* Cust Item ID:

Required Date: 3/30/2016 Req'd Qty: 25.00 *25* Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAR 10 2016 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3885	C

102		0.00							
102									
Skidtubes	Memo								
Skidtubes	CUT BLANK TO 115.00"								

105		0.00							
105									
QC	Memo								
Quality Control									

0.00
part at wejay

25 MAR 15 2016 DAS 13

25x 80/6-05-19

N/A

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.07				25		16-5-26	
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00				25		16-05-26	
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								

DAS 19 9-89

DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
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OTHER : ☐									

Work Order ID 142573***142573***

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Required Date: 3/30/2016 Req'd Qty: 25.00 *25* Customer:
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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.04							
Quality Control									

MCS MAY 3 0 2016

MCS MAY 3 0 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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		OTHER : ☐							

Picklist Print

Thursday, March 10, 2016 10:48:05 AM

Page 1

Work Order ID: 142573

142573

Parent Item: D3885-1

D3885-1

Parent Item Name: Standard Web

Start Date: 3/14/2016

Required Date: 3/30/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3885-1P		Purchased	No				Each	0.0000		25			
D3885-1P									**	25x			
Standard Web													
D3882-1-130		Manufactured	No			110	Each	67.0000	1	(25)			
D3882-1-130									**				
Extrusion "I" Beam													

MAR 15 2016
DAS 13
9-89

Location

WEJAY

119702

137403

Loc Qty

67

2

65

Loc Code

✓ 2
✓ 23

DQA: _____ Date: _____

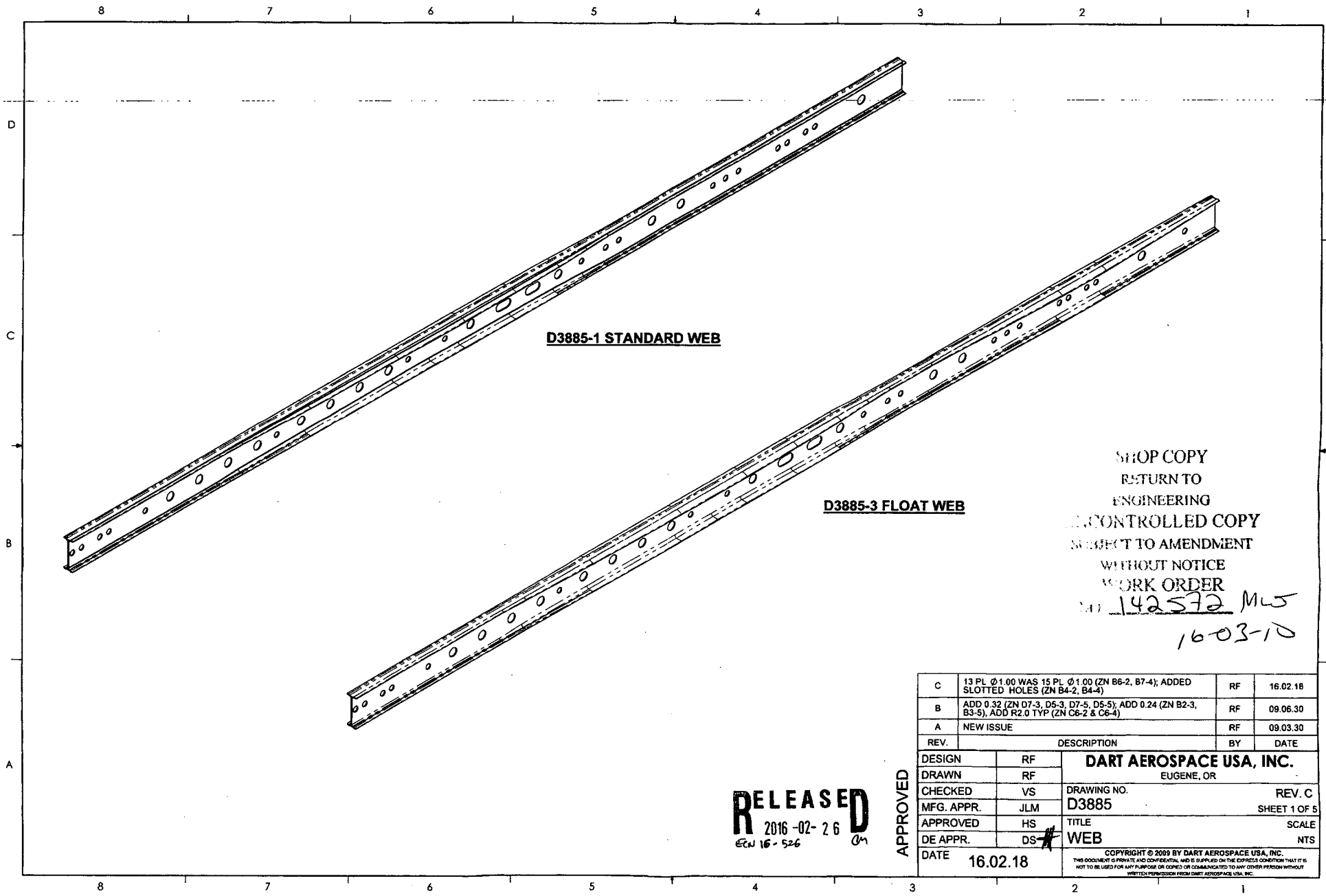


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					



D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 142572 ML5
 1603-10

C	13 PL Ø1.00 WAS 15 PL Ø1.00 (ZN B6-2, B7-4); ADDED SLOTTED HOLES (ZN B4-2, B4-4)	RF	16.02.18
B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5); ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
 2016-02-26
 ECU 16-526

APPROVED

DQA: _____ Date: _____

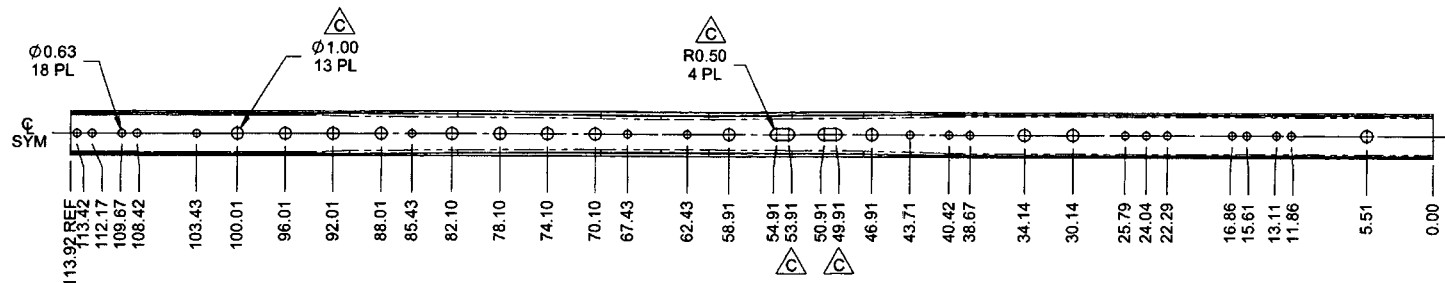
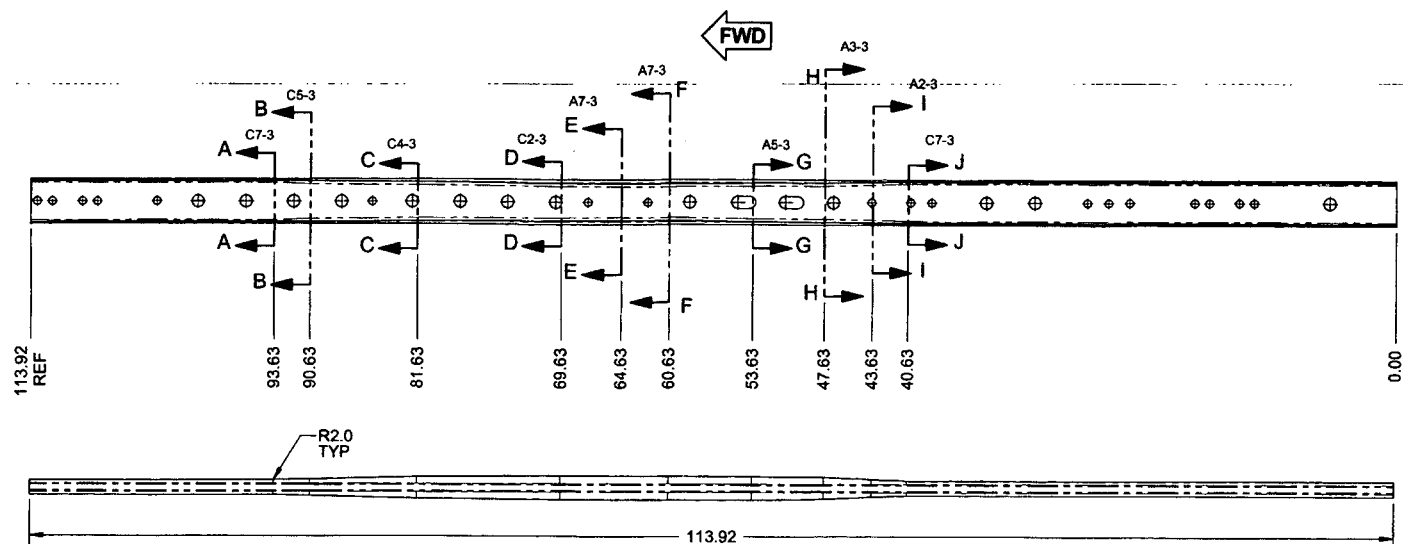


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							



D3885-1 STANDARD WEB

D3885-1 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.49 lbs

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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DQA: _____ Date: _____

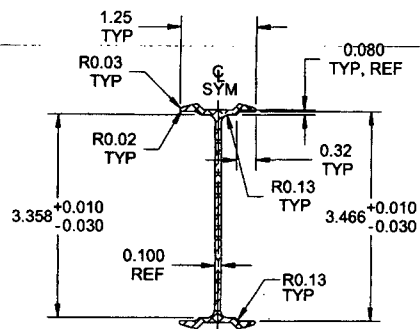


WORK ORDER NON-CONFORMANCE / UPDATE

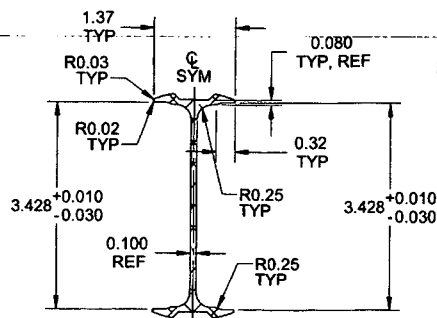
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Work Order update only ☐

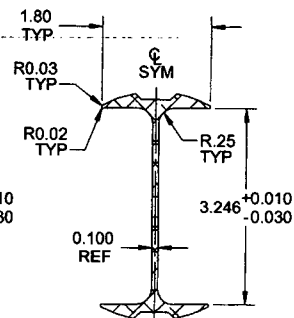
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☐ OTHER : _____					



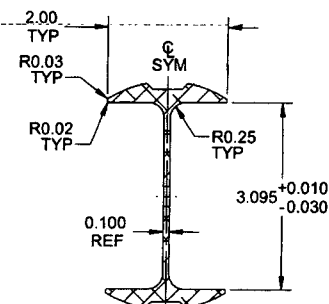
**SECTION A-A
& SECTION J-J**
SCALE 5X
D6-2
D4-2



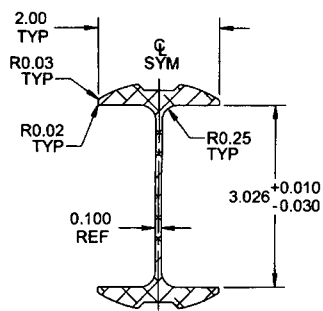
SECTION B-B
SCALE 5X
D6-2



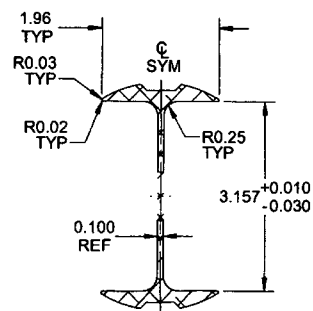
SECTION C-C
SCALE 5X
D6-2



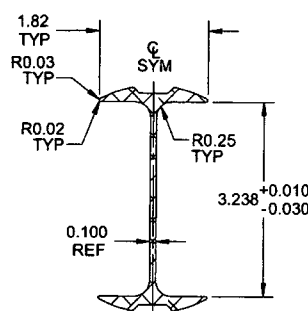
SECTION D-D
SCALE 5X
D5-2



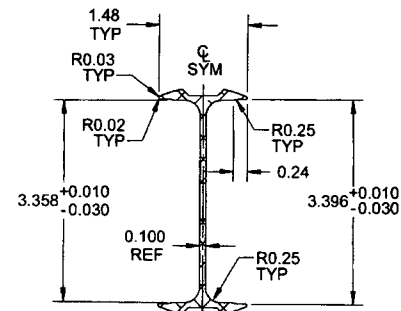
**SECTION E-E
& SECTION F-F**
SCALE 5X
D5-2



SECTION G-G
SCALE 5X
D4-2



SECTION H-H
SCALE 5X
D4-2



SECTION I-I
SCALE 5X
D4-2

D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO. D3885	REV. C
MFG. APPR.	JLM	SHEET 3 OF 5	
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DE APPR.	DS	WEB	NTS
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DQA: _____ Date: _____

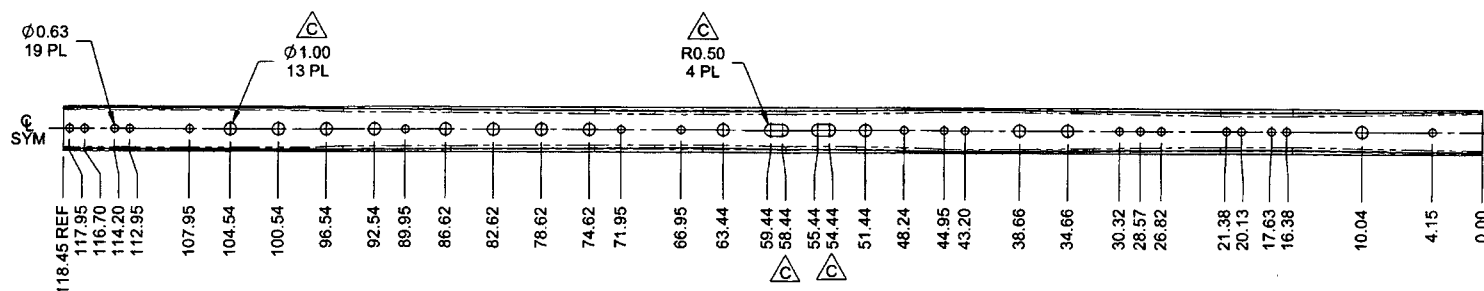
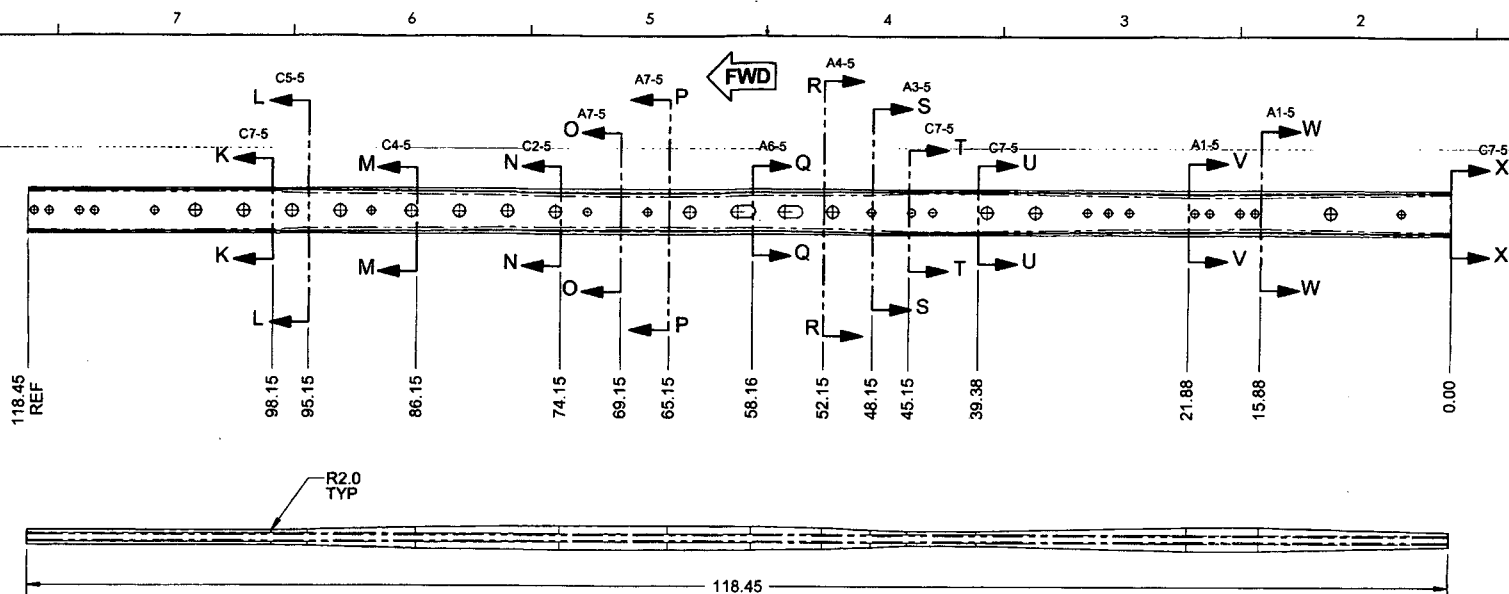


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



D3885-3 FLOAT WEB

D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 004 6.1
- 7) WEIGHT: 10.14 lbs

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
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DQA: _____ Date: _____



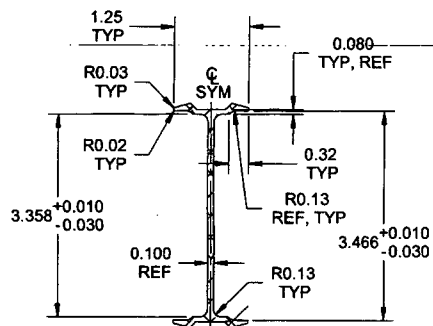
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

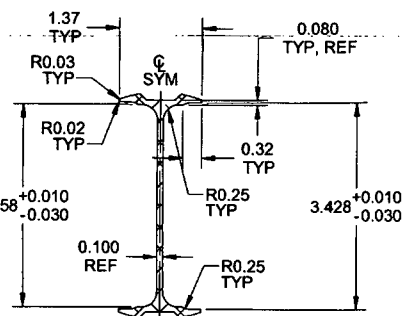
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

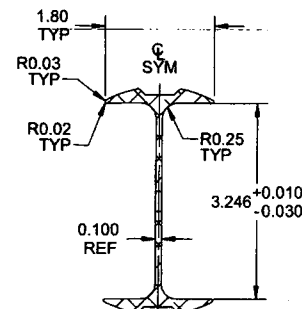
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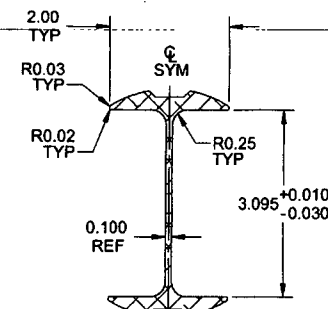
**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X
D7-4
D4-4
D3-4
D1-4



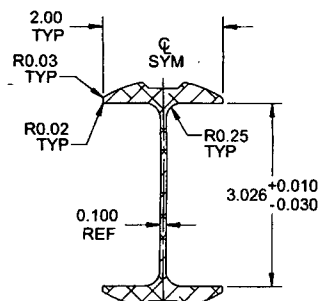
SECTION L-L D6-4
SCALE 5X



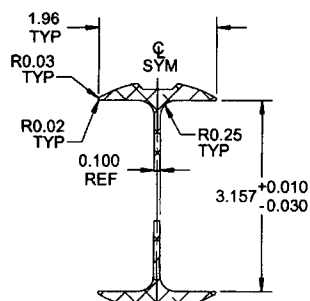
SECTION M-M D6-4
SCALE 5X



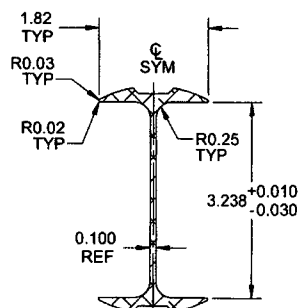
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SCALE 5X



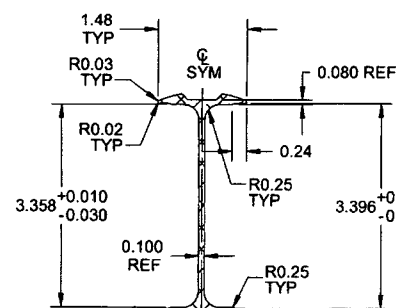
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



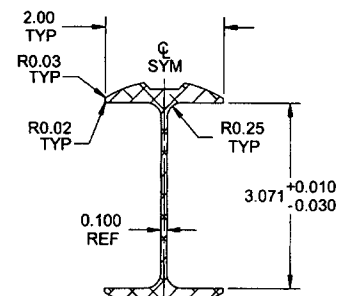
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31700

Purchase Order Date 3/15/2016

PO Print Date 3/15/2016

Page Number 1 of 2

Order From :

VC-WMP001

Ship To : DART AEROSPACE LTD

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

MAR 15 2016

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Journey Freight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D3885-1P	Standard Web	5/5/2016 Yes 5/5/2016		25.00 Each	\$495.00	\$12,375.00
	AS PER DWG D3885 REV. C B142573						
						Line Total:	\$12,375.00
2	D4977-2P	Bracket, RH	5/5/2016 Yes 5/5/2016	FN	4.00 Each	\$425.00	\$1,700.00
	AS PER DWG D4977 REV. D B142577						
						Line Total:	\$1,700.00

PO Instructions: QUOTATION NO: WJ-8922

Note:

3/15/2016



Packing Slip 37901
600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA	
		31700		03/16/16		Best way	
CUSTOMER CODE			PROV. LIC. NO.		TERMS		
DART							
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
25	0	25	Standard web as per drawig D3885 Rev. C D3885-1P B142573				
4	0	4	Bracket, right hand, as per drawing D4977, Rev. D D4977-2P B142577				
<i>Sp/6-05-09</i>							
Required by: May ¹⁸ 2016							
RELEASE NOTE							
I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.							
Inspection Supervisor <i>[Signature]</i>						G.S.T.	
						P.S.T.	
ORDER: COMPLETE ☐ PARTIAL ☐						TOTAL	

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: May 12, 2016	
		P.O.# PO21700	
		WEJAY JOB# 37901	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-1P 'Standard Web' B142573	25	Machined complete per drawing req'ts.	D3885 / rev. D
Note: 1) Material: Aluminum extrusions supplied by Dart Aerospace. 2) 1st Article and Final Inspection/ Test Reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,



Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.
37901

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# 31700

PART No. D3885-1P

DESCRIPTION: Standard Web **SN001/31700**

DWG No. D3885

REV. C

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

E. JANSEN

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: -

N.C.R.# -

DATE:

APRIL/21/2016.

INSTRUCTIONS, COMMENTS:

Inspect incoming web extrusions per drawing D3882-1-130 before machining

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
	FIRST ARTICLE.						

1	Hole, Diameter .63"	18 places	+ .008/- .001		.630 - .632		ACC
2	Hole, Diameter 1.00"	13 places	+ .010/- .001		1.0005 - 1.001		ACC
3	5.51"		+/- .03		5.515		ACC
4	11.86"		+/- .03		11.857		ACC
5	13.11"		+/- .03		13.107		ACC
6	15.61"		+/- .03		15.6065		ACC
7	16.86"		+/- .03		16.855		ACC
8	22.29"		+/- .03		22.292		ACC
9	24.04"		+/- .03		24.042		ACC
10	25.79"		+/- .03		25.791		ACC
11	30.14"		+/- .03		30.134		ACC
12	34.14"		+/- .03		34.1345		ACC
13	38.67"		+/- .03		38.667		ACC
14	40.42"		+/- .03		40.418		ACC
15	43.71"		+/- .03		43.715		ACC
16	46.91"		+/- .03		46.910		ACC
17	49.91"		+/- .03		49.9115		ACC
18	44.41"		+/- .03		44.4115		ACC
19	50.91"		+/- .03		50.9115		ACC
20	53.91"		+/- .03		53.9125		ACC
21	54.91"		+/- .03		54.9125		ACC
22	58.91"		+/- .03		58.9115		ACC
23	62.43"		+/- .03		62.4365		ACC
24	67.43"		+/- .03		67.4375		ACC
25	70.10"		+/- .03		70.0995		ACC
26	74.10"		+/- .03		74.0985		ACC
27	78.10"		+/- .03		78.0985		ACC
28	82.10"		+/- .03		82.098		ACC
29	85.43"		+/- .03		85.4345		ACC
30	88.01"		+/- .03		88.0145		ACC
31	92.01"		+/- .03		92.0145		ACC
32	96.01"		+/- .03		96.0145		ACC
33	100.01"		+/- .03		100.015		ACC
34	103.43"		+/- .03		103.434		ACC
35	108.42		+/- .03		108.424		ACC



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

37901

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# 31700

PART No. D3885-1

DESCRIPTION: Standard Web *SN 001/31700*

DWG No. D3885

REV. C

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

36	109.67		+/- .03		<i>109.674</i>		<i>ACC</i>
37	112.17		+/- .03		<i>112.1745</i>		<i>ACC</i>
38	113.42		+/- .03		<i>113.425</i>		<i>ACC</i>
39	113.92 REF				<i>113.92</i>		<i>ACC</i>
40	1.25" TYP	Section A-A,J-J@93.63",40.63"			<i>1.253</i>		<i>ACC</i>
41	R.03" TYP				<i>R.03</i>		<i>ACC</i>
42	R.02" TYP				<i>R.02</i>		<i>ACC</i>
43	3.358"		+0.010/-0.030		<i>3.359</i>		<i>ACC</i>
44	R.13" TYP				<i>R.13 - R.125</i>		<i>ACC</i>
45	.32" TYP				<i>.325</i>		<i>ACC</i>
46	3.466"		+0.010/-0.030		<i>3.465</i>		<i>ACC</i>
47	R.13" TYP				<i>R.13 - R.125</i>		<i>ACC</i>
48	.080 TYP,REF				<i>.080</i>		<i>ACC</i>
49	1.37" TYP	Section B-B@90.63"			<i>1.374</i>		<i>ACC</i>
50	R.03" TYP				<i>R.030</i>		<i>ACC</i>
51	R.02" TYP				<i>R.02</i>		<i>ACC</i>
52	3.428"	2 places	+0.010/-0.030		<i>3.432</i>		<i>ACC</i>
53	R.25" TYP				<i>R.25</i>		<i>ACC</i>
54	.32" TYP				<i>.32</i>		<i>ACC</i>
55	R.25" TYP				<i>R.25</i>		<i>ACC</i>
56	.080" TYP,REF				<i>.080</i>		<i>ACC</i>
57	1.80" TYP	Section C-C@81.63"			<i>1.803</i>		<i>ACC</i>
58	R.03" TYP				<i>R.03</i>		<i>ACC</i>
59	R.02" TYP				<i>R.02</i>		<i>ACC</i>
60	3.246"		+0.010/-0.030		<i>3.248</i>		<i>ACC</i>
61	R.25" TYP				<i>R.25</i>		<i>ACC</i>
62	2.00" TYP	Section D-D@69.63"			<i>1.987</i>		<i>ACC</i>
63	R.03" TYP				<i>R.03</i>		<i>ACC</i>
64	R.02" TYP				<i>R.02</i>		<i>ACC</i>
65	3.095"		+0.010/-0.030		<i>3.098</i>		<i>ACC</i>
66	R.25" TYP				<i>R.25</i>		<i>ACC</i>
67	2.00" TYP	Section E-E,F-F@64.63",60.63"			<i>1.988</i>		<i>ACC</i>
68	R.03" TYP				<i>R.03</i>		<i>ACC</i>
69	R.02" TYP				<i>R.02</i>		<i>ACC</i>
70	3.026"		+0.010/-0.030		<i>3.026 - 3.030</i>		<i>ACC</i>



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

37901

PAGE: 3 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# 31700

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. C

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

73	R.25" TYP				R.25		ACC
74	1.96"	Section G-G @53.63"			1.957		ACC
75	R.03" TYP				R.03		ACC
76	R.02" TYP				R.02		ACC
77	3.157"		+0.010/-.030		3.158		ACC
78	R.25" TYP	Section G-G Cont'd			R.25		ACC
79	1.82"	Section H-H@47.63"			1.818		ACC
80	R.03" TYP				R.03		ACC
81	R.02" TYP				R.02		ACC
82	3.238"		+0.010/-.030		3.240		ACC
83	R.25" TYP				R.25		ACC
84	1.48"	Section I-I@43.63"			1.486		ACC
85	R.03" TYP				R.03		ACC
86	R.02" TYP				R.02		ACC
87	3.358		+0.010/-.030		3.358		ACC
88	R.25" TYP				R.25		ACC
89	3.396"		+0.010/-.030		3.399		ACC
90	R.25" TYP				R.25		ACC
91							
92							
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600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37901

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO31700

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

CLIFF SMITH

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: --

N.C.R.# --

DATE:

MAY 13/16

INSTRUCTIONS, COMMENTS: 1st ARTICLE INSPECTION / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	Hole, Ø .63"	18 places	+ .008/- .001		.631 - .633	1	Acc.
2	Hole, Ø 1.00"	15 places	+ .010/- .001		1.001 - 1.002	1	"
3	Slot, R 0.50	2 places	+ .010/- .001		.500 - .501	1	"
4	5.51"		± .03		5.513	1	"
5	11.86"		± .03		11.855	1	"
6	13.11"		± .03		13.105	1	"
7	15.61"		± .03		15.604	1	"
8	16.86"		± .03		16.853	1	"
9	22.29"		± .03		22.290	1	"
10	24.04"		± .03		24.040	1	"
11	25.79"		± .03		25.790	1	"
12	30.14"		± .03		30.132	1	"
13	34.14"		± .03		34.132	1	"
14	38.67"		± .03		38.664	1	"
15	40.42"		± .03		40.415	1	"
16	43.71"		± .03		43.708	1	"
17	46.91"		± .03		46.905	1	"
18	49.91"		± .03		49.905	1	"
19	50.91"		± .03		50.905	1	"
20	53.91"		± .03		53.905	1	"
21	54.91"		± .03		54.905	1	"
22	58.91"		± .03		58.904	1	"
23	62.43"		± .03		62.428	1	"
24	67.43"		± .03		67.427	1	"
25	70.10"		± .03		70.090	1	"
26	74.10"		± .03		74.093	1	"
27	78.10"		± .03		78.094	1	"
28	82.10"		± .03		82.094	1	"
29	85.43"		± .03		85.431	1	"

INSPECTION / TEST REPORT

JOB No. 37901

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO31700

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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30	88.01"		± .03		88.012	1	Acc.
31	92.01"		± .03		92.015	1	"
32	96.01"		± .03		96.014	1	"
33	100.01"		± .03		100.014	1	"
34	103.43"		± .03		103.432	1	"
35	108.42"		± .03		108.421	1	"
36	109.67"		± .03		109.671	1	"
37	112.17"		± .03		112.170	1	"
38	113.42"		± .03		113.420	1	"
39	113.92" o.a.		± .03		113.921	1	"
40	1.25" TYP	Section A-A, J-J	± .03		1.257-1.276	1	"
41	R.03" TYP		± .03		R.02-.04	1	"
42	R.02" TYP		± .03		R.02-.03	1	"
43	3.358"		+0.010/-0.030		3.354-3.367	1	"
44	R.13" TYP		± .03		R.13 TYP.	1	"
45	.32" TYP		± .03		.325-.332	1	"
46	3.466"		+0.010/-0.030		3.455-3.476	1	"
47	R.13" TYP		± .03		R.130 TYP.	1	"
48	.080 TYP, REF		± .03		.080 TYP.	1	"
49	1.37" TYP	Section B-B	± .03		1.381-1.386	1	"
50	R.03" TYP		± .03		R.02-.04	1	"
51	R.02" TYP		± .03		R.02-.03	1	"
52	3.358"	(NOT SHOWN ON DWG)	+0.010/-0.030		3.353-3.368	1	"
53	R.25" TYP		± .03		R.250 TYP.	1	"
54	.32" TYP		± .03		.316-.320	1	"
55	R.25" TYP		± .03		R.250 TYP.	1	"
56	3.428"		+0.010/-0.030		3.419-3.436	1	"
57	1.80" TYP	Section C-C	± .03		1.803-1.805	1	"
58	R.03" TYP		± .03		R.02-.04	1	"
59	R.02" TYP		± .03		R.02-.03	1	"
60	3.246"		+0.010/-0.030		3.237-3.255	1	"
61	R.25" TYP		± .03		R.250	1	"
62	2.00" TYP	Section D-D	± .03		1.983-1.986 (STOCK)	1	"
63	R.03" TYP		± .03		R.02-.04	1	"
64	R.02" TYP		± .03		R.02-.03	1	"

INSPECTION / TEST REPORT

JOB No. 37901

PAGE: 3 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO 31700

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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65	3.095"		+0.010/-0.030		3.080-3.102	1	Acc.
66	R.25" TYP		± .03		R.250 TYP.	1	"
67	2.00" TYP	Section E-E, F-F	± .03		1.983-1.986 (stock)	1	"
68	R.03" TYP		± .03		R.02-.04	1	"
69	R.02" TYP		± .03		R.02-.03	1	"
70	3.026"		+0.010/-0.030		3.006-3.050 (stock)	1	"
71	R.25" TYP		± .03		R.250 TYP.	1	"
72	1.96"	Section G-G	± .03		1.962-1.965	1	"
73	R.03" TYP		± .03		R.02-.04	1	"
74	R.02" TYP		± .03		R.02-.03	1	"
75	3.157		+0.010/-0.030		3.140-3.167	1	"
76	R.25" TYP		± .03		R.250 TYP.	1	"
77	1.82"	Section H-H	± .03		1.823-1.825	1	"
78	R.03" TYP		± .03		R.02-.04	1	"
79	R.02" TYP		± .03		R.02-.03	1	"
80	3.238"		+0.010/-0.030		3.225-3.240	1	"
81	R.25" TYP		± .03		R.250 TYP.	1	"
82	1.48"	Section I-I	± .03		1.481-1.492	1	"
83	R.03" TYP		± .03		R.02-.04	1	"
84	R.02" TYP		± .03		R.02-.03	1	"
85	3.358		+0.010/-0.030		3.348-3.362	1	"
86	R.25" TYP		± .03		R.250 TYP.	1	"
87	3.396"		+0.010/-0.030		3.382-3.405	1	"
88	R.25" TYP		± .03		R.250 TYP.	1	"